

634-011

Dart Aerospace Ltd.

Date: Tuesday, 16/12/2008 11:57:14 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SKID TUBE ASSEMBLY
<b>Job Number</b> :	44104A		
<b>Estimate Number</b> :	10023		
<b>P.O. Number</b> :		<b>Part Number</b> :	D205634041
<b>This Issue</b> :	16/12/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2580 REV D
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	43667A	<b>Drawing Revision</b> :	D
		<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	05/01/2009
<b>Checked &amp; Approved By</b> :	JLD 08.12.16		
<b>Comment</b> :	Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ Est Rev:O 06.02.28 Added paperwork EC Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM		

Qty: 1 Um: Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634-041 CHG002

N/A

2.0

D25001190

Ext'n -I' Beam Tube 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2500-1-190

Skid Tube Extrusion

B40150

a.m 08.12.18

3.0

D2596

Web, 205 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2596

205 Web

B43932

Pm 08-12-19

4.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

a.m 08.12.18

2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends

a.m 08.12.18

3-Acid etch and Alodine tube per QSI 005 4.1

a.m 08.12.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No / DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 44104A

Part Number: D205634041

Job Number:



Seq. #: Machine Or Operation: Description :

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*BE 08/12/23*

10.0 D25763 Step (maching detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	<i>38392</i>

*BE 08/12/23*

11.0 D2579 Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	<i>43751</i>

*BE 08/12/23*

12.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

*m/09560*

*BE 08/12/23*

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

*m/09560*

*BE 08/12/23*

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

*AWM 8-12-24*

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

*AWM 8-12-24*

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

7-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

*SL8-12-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 44104A

Part Number: D205634041

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08.12.29

14.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.12.29

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Pressure wash as per QSI 005

HL

09-06-01

XL

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M109996

XL

START TIME:

3:10

OVEN TEMPERATURE:

320°

FINISH TIME:

3:40

FZ 09/01/08

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-09-01

XL

18.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: 1342928

HL

19.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M100188

HL

09-09-01

XL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 44104A

Part Number: D205634041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

20.0	AN960JD10L	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M105793

W

21.0	ALS71032130	Insert
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Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Insert

Batch: M105819

W

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22.0	AN3C4A	BOLT
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Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

BOLT

Batch: M110372

W

23.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

washer

Batch: M110139

W

24.0	D356613	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B42147

W

25.0	D35665	Gasket
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B43710

W

26.0	D35661	Gasket
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: B43709

W

09-09-01

(K)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 44104A

Part Number: D205634041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	D356413	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 1342257

*210*

28.0	D356411	Wearshoe
------	---------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 1343702

*210*

29.0	D35649	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 1343708

*210*

30.0	D35645	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 1343893

*210*

31.0	D25943	O-Ring, 205 Skidtube
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

O-Ring

Batch: 1329908

*210*

32.0	D25941	Plug, 205 Skidtube
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Plug

Batch: 1341434

*210*

33.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R

Sikaflex-291

M109883

*210*

09-09-01

(41)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 44104A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ Sikaflex expire date: 09/11

✓ 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

✓ 3-Inspect for foreign object per QSI 024

✓ 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

✓ A/R Sikaflex-291 M105883  
Sikaflex expire date: 09/11

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M109917

- FL 09/01/13 ①

34.0

QC5

INSPECT WORK TO CURRENT STEP



S 09/01/13 ①



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location: \_\_\_\_\_

PPP Rev: PPP 44/04

09/01/15 ①

36.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/15 HJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



09.01.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART****RELEASED**  
07-06-28 #

DESIGN #	DRAWN BY RH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL  $\varnothing 0.297$  HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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Diagram illustrating the cross-section of a pipe with four vertical stiffeners. The stiffeners are spaced 3.500 units apart. The distance from the centerline to the outer edge of the stiffeners is 1.750 units.

RELEASED  
07-06-28

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the component with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576

Technical drawing of a bolted joint assembly. The drawing shows a cross-section of a bolted joint. The components and dimensions are labeled as follows:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to the two locations where the cap is installed.
- SEAL WITH SIKAFLEX-241/-291**: Points to the sealant applied to the joint.
- AN3-5A BOLT (1)**: Points to the bolt.
- AN96QJD10L WASHER (1)**: Points to the washer.
- (2 PLACES)**: Points to the two locations where the washer is installed.
- D2855 CAP**: Points to the cap.
- 0.208**: Dimension indicating the diameter of the hole.
- 0.40**: Dimension indicating the thickness of the plate.

D2579 SPACER  
 D2596 WEB (REF)  
 ALS7-1032-130 (REF)  
 (TYP 50 PLACES)

AFTER DRILLING AND BENDING ASSEMBLY  
 PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

37.50  
DISTANCE TO AFT END  
OF D2596 WEB

3  
7

1.750  
1.750

Ø0.508 (TYP.)  
(40 PLACES)

REFER TO DETAIL A

REFER TO DETAIL A

8.750  
17.375  
26.000  
34.188

57.313 (REF)  
7 EQUAL SPACES  
8.188 PITCH

38.0  
91.500  
190.0  
(D2500-1)

Technical drawing of a road cross-section showing a drainage ditch. The ditch is 1.4m wide at the top and 1.0m wide at the bottom. The distance between the hole and the tangent point is 13.4m. The ditch is 32.0 ± 1.0m long. The slope is 20.0% and the hole diameter is Ø0.640.

[illegible]

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07.02.27

1

205 SKIDTUE

ASSEMBLY 1

RELEASED  
07-01-28

Diagram illustrating the grinding locations for the D2576-3 STEP component. The component is a long, narrow, oval-shaped part with a central hole. The grinding locations are indicated by arrows and labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{4}$

Diagram illustrating the installation of a D2855 cap on a circular component. The diagram shows a cross-section of the component with a central rectangular area. A bolt and washer are shown passing through the center. The following labels and dimensions are provided:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)
- SEAL WITH SIKAFLEX-241/-291
- AN3-5A BOLT (1)
- AN960JD10L WASHER (1) (2 PLACES)
- D2855 CAP
- SEE NOTE ii)
- 0.40

D2579 SPACER

D2596 WEB (REF)

ALS7-1032-130 (REF)  
(TYP 50 PLACES)

AFTER PERFORM  
1. CHA  
2. INS  
3. WEI  
4. C'E

5

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB. POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

[illegible][illegible][illegible]

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REV. D  
SHEET 3 OF 3  
SCALE  
1:24

